

IN THE SPECIFICATION:

Please amend paragraphs [0014], [0017], [0018], [0020] and [0021] as follows:

[0014] ~~Fig. 4 -7 depict steps~~ depicts a first step in a process for fabricating the wax shell imitation candle of Fig. 3.

[0014A] Fig. 5 depicts a subsequent process step following the step of Fig. 4.

[0014B] Fig. 6 depicts a subsequent process step following the step of Fig. 5.

[0014C] Fig. 7 depicts a subsequent process step following the step of Fig. 6.

[0017] Insert 12 is undersized compared to the cavity 14 in which it is to be retained. Bonding between a plastic insert casing 18 is provided by bonding layer 20 which lines the upper portion of cavity 14 between casing 18 and interior surface 15. As described below, bonding layer 20 is formed by a second pouring of a small quantity of molten wax into an inverted, but already cooled and hardened shell 10. Bonding layer 20 is shaped by fitting insert 12 into cavity 14 while the second poured wax is still molten. Bonding layer 20 does not line all of interior surface 15 in the preferred embodiment, but only enough to cover casing 18 around LED 16 and about the top half of the main body of insert 12. An air gap 30 surrounds the bottom half of insert 14 spacing the insert from interior surface 15. The top ~~34~~ 32 of illumination module 14 abuts an upper horizontal face 34 of interior surface 15, displacing molten wax and positioning the illumination module vertically. Horizontal positioning of illumination module may be achieved by careful reference to the spacing between casing 18 and interior surface 15 and by the careful, mutually parallel orientation of the elements. The bottom surface of insert 12 is slightly recessed (2.5 mm) from the surrounding bottom surface of shell 10 allowing accurate determination disposition of the insert in cavity 14.

[0018] While use of a bonding layer 20 is preferred due to the assurance of a

good fit between the bonding layer and insert **12**, it is possible to substitute a molded or shaped shoulder **60** which is formed as part of interior surface **15** defining cavity **14**. As seen in **Fig. 3B** shoulder **60** is part of shell **42 10** and slants inwardly into cavity **14** partway into the cavity from the bottom surface of shell **10**. Construction of shell **10** to incorporate such a circumferential shoulder is easily done by modification of the bit used to shape cavity **14** or form **42**. It is important that a gap be left between the body of insert **12** and interior surface **15** in the lower part of cavity **14**. This saves processing steps. However, the difficulty in this technique is that extremely close tolerances in dimensional matching between the insert **12** and the shell **10** are required to avoid introducing stress on introducing the insert to cavity **14**. It may be possible to time the introduction to a point while the wax of shell **10** is still slightly soft.

[0020] After pouring of the wax for shell **42 10** the wax is allowed to cool. Where no form is used the wax is allowed to cool until the wall thickness is at least 10 mm. Where a form **42** is used the wax is allowed to cool until the entire shell **10** has hardened. A water bath may be used to expedite the cooling process. If no form was used a hole is formed into the cooling body from what will become the bottom surface of the shell to the interior, still molten wax. The mold is partially inverted to allow the molten wax to be poured out and reclaimed. Removal of the central, molten wax speeds the cooling process and relieves stress on the walls of shell **10**. The shell continues cooling, again potentially placed in a water bath to quicken the process. Mold **40** is advantageously shaped to impress an upper surface central depression into shell **10**. Where, however, the mold did not incorporate such a shape, a bit contoured with the cross section of the upper surface may be used to shape the upper surface after withdrawal of the shell **10** from mold **40**.

[0021] The position of insert **12** is controlled by the depth of cavity **14**. An inner bit may be used trim the bottom of shell **10** and to machine cavity **40 14** where no interior form **42** is used, or where adjustment of the shape of a cavity left by a form is required. Shell **10** should be properly fixtured during shaping with a bit to insure a

uniform core depth and candle height.